

Work Order ID 83786

Wednesday, April 25, 2012 2:35:31 PM

83786

Page 1

Item ID: D2221

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 Basket Base

Start Date: 5/4/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *12-04-25* Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2221	Rev H								

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100 Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: *118366*

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

110		0.00							
-----	--	------	--	--	--	--	--	--	--

110 QC

Quality Control

Memo

0.00

QC9- Inspect visual per QSI004- Fusion Welds

1 *φ* *ll*
12.05.23

1x *pl* *12.05.24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

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Revision ID:

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Stop ***NS2***

Start Date: 5/4/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

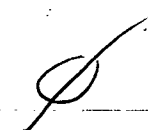
125

HandFinish

Memo

0.00

Hand Finishing

IX  M-L
12/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/11/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to								
	IST COAT: 9'-50								
	START TIME: 4000 F								
	OVEN TEMPERATURE:								
	FINISH TIME: 10-20								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

M121134

1X

M-1
12/25/29

1 φ

BD 12-5-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 350 Basket Base

Stop ***NS2***

Start Date: 5/4/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: D350-607-043

0.00

150

Packaging

Memo

0.00

Packaging

1

1

PR 12-5-29

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MF
12-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 83786
Parent Item: D2221
Parent Item Name: 350 Basket Base

Start Date: 5/4/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	4.0000	1	1		Ac 12.05.17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		4							
				80163		4							
D2221-5 Rib		Manufactured	No			100	Each	6.0000	2	2		Ac 12.05.17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA006		6							
				67117		2							
				78637		4							
D2221-7 Rib		Manufactured	No			100	Each	4.0000	1	1		Ac 12.05.17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA006		4							
				81041		4							
D2232-3 Basket Hinge		Manufactured	No			100	Each	17.0000	2	2		Ac 12.05.17	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		13							
				82304		13							
				WA005		4							
				75581		2							
				78903		2							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/4/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

D2235-1 Manufactured No 100 Each 19.0000
Basket Rib

2 2 882951 (2) Ae 12.05.17

Location	Loc Qty	Loc Code
WA	14	
78636	5	
81910	9	
WA005	5	
66895	4	
79153	1	

D2581 Manufactured No 100 Each 92.0000
Mounting Bracket

2 2 Ae 12.05.17

Location	Loc Qty	Loc Code
WA	9	
82506	9	
WA005	83	
70766	2	
81253	1	
82017	40	
82897	40	

D3442-1 Manufactured No 100 Each 23.0000
Shim

2 2 Ae 12.05.17

Location	Loc Qty	Loc Code
WA	20	
80788	20	
WA005	3	
71783	3	

D3825-041 Manufactured No 100 Each 2.0000
Rib Assembly (Basket End)

2 2 Ae 12.05.17

Location	Loc Qty	Loc Code
WA	2	
78638	2	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/4/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3826-041 Manufactured No 100 Each 2.0000 2

Rib / Gusset Assembly

2 883909 (2) Ae 12.05.17

Location Loc Qty Loc Code

WA 2

81398 2

D3827-041 Manufactured No 100 Each 3.0000 1 1

Rib Assembly (Inboard)

Ae 12.05.17

Location Loc Qty Loc Code

WA006 3

72729 1

77546 2

D3832-1 Manufactured No 100 Each 0.0000

Mesh (Base)

84068

(1) → 1 26.79 Ae 12.05.17

D3833-1 Manufactured No 100 Each 13.0000 2 2

Mesh (Base End Face)

Ae 12.05.17

Location Loc Qty Loc Code

WA 5

77521 5

WA035 8

81259 8

(2)

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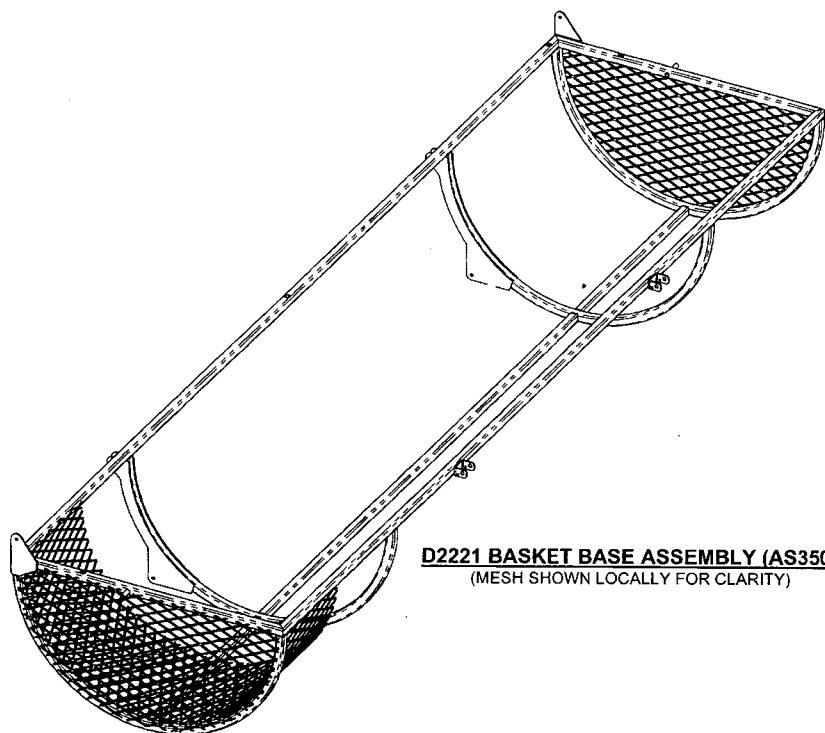
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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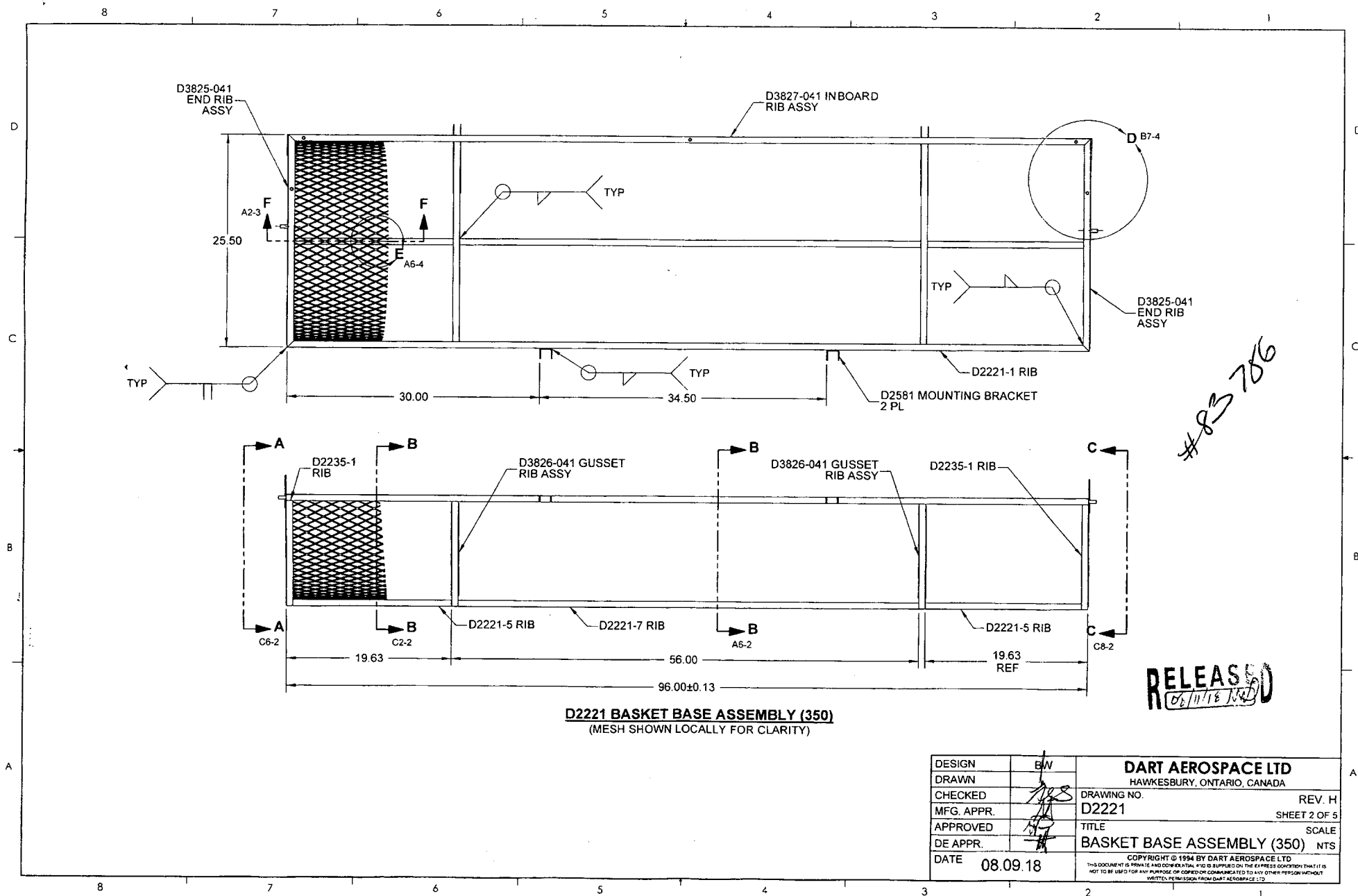
D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

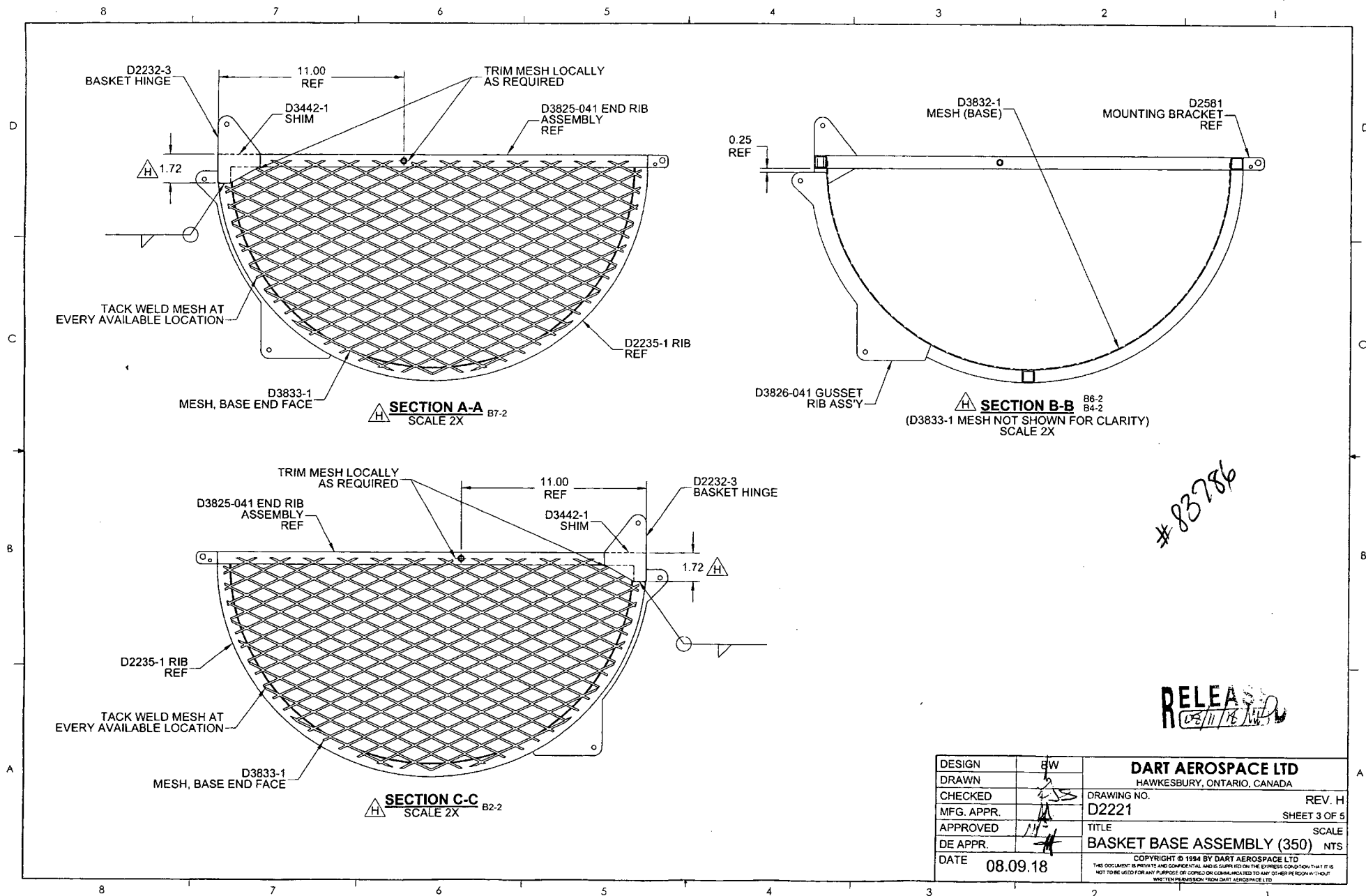
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW REF (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON A "AS IS" BASIS. IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





#83786

RELEASED
03/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	235	HAWKESBURY, ONTARIO, CANADA	
CHECKED	14	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8

7

6

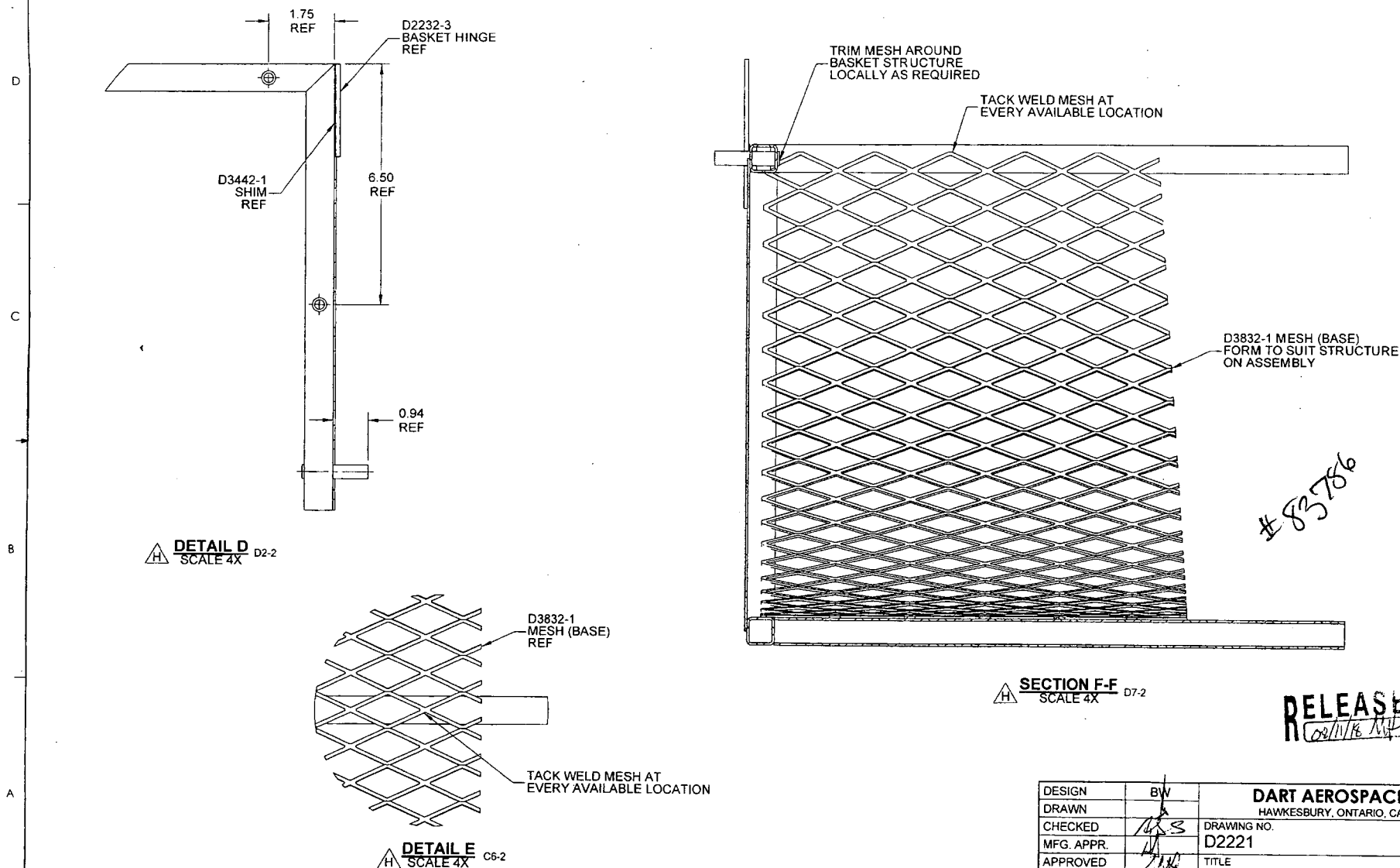
5

4

3

2

1



DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	14.5	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	14.5	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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